

Work Order ID 78025

December-23-11 11:15:28 AM

78025

Page 1

Item ID: D2596

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Web, 205 Skidtube

Start Date: 23/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: M.L.JDate: 11/12/23

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2596

Rev D

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Cut D2500-3-100 to length: 99.5"
2- Use Jig DT8093 to drill pilot holes #30
3- Open to 0.630" diameter as per Dwg D2596
4- Deburr

110

Chemical Conversion Coat per QSI005 4.1

0.00

110

HandFinish

Memo

0.00

Hand Finishing

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

④

SAD

12-1-9

④

SAD

12-1-10

④

12-1-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78025

78025

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

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Item Name: Web, 205 Skidtube

Start Date: 23/12/2011 Start Qty: 4.00

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Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 4.00

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Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 46

0.00

130

Packaging

Memo

0.00

Packaging

DP 12-1-10 (4)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/1/12 MF 12-01-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

December-23-11 11:15:31 AM

Work Order ID: 78025

78025

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 23/12/2011

Required Date: 29/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	54.0000	1	4			
										**			

D2500-3-100

Ext'n - 'I' Beam Web 4"

Location

Loc Qty

Loc Code

LG

54

51957

2

66298

52

(4)

EP/SP

12-1-9

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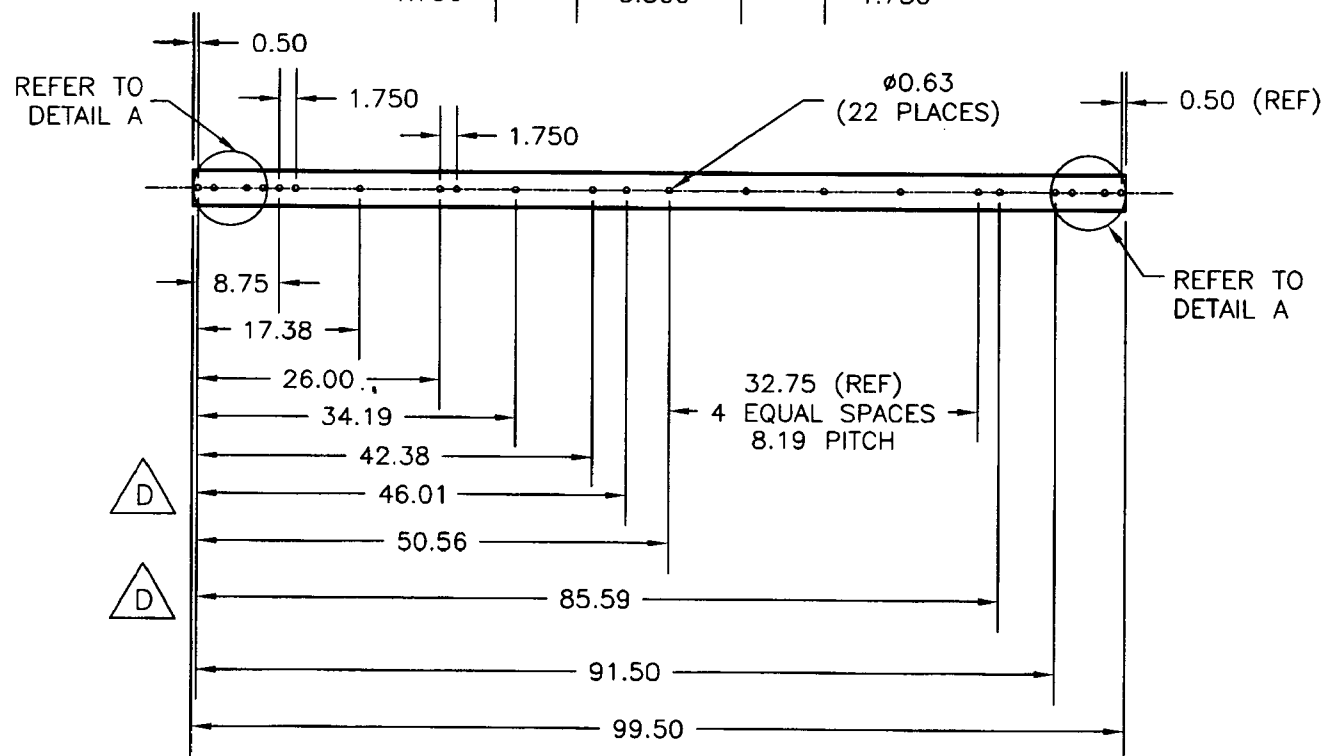
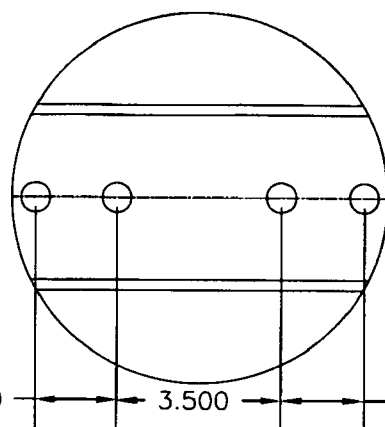
NOTE: Date & initial all entries

DART

RELEASED
07 DEC 68

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78025 M.L.J.
11/12/23

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN		DRAWN BY		DART AEROSPACE LTD	
A4		A4		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. D	
		D2596		SHEET 1 OF 1	
DATE		TITLE		SCALE	
07.04.17		205 WEB		1:20	
A	96.09.16	NEW ISSUE			
B	97.07.23	Ø0.63 HOLE WAS Ø0.56			
C	98.09.14	INCORPORATED DEO 9097			
D	07.04.17	INCORPORATED DEO 9183			

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